Work Ord Tuesday, Novem							* .					Page 1
Item ID: Revision ID:	D3502-1			Accept				S	Setup			
Item Name: Start Date: Required Date: Reference:	Support 11/22/2010 12/15/2010	Start Qty: 10.00 Req'd Qty: 10.00	* 1888 1811 1811 1811 1888 1811 1811 1811		Cust Item II Customer:):				Stop		
Approvals:	Process Plan	n:	Date: /0-//	Tooling: SPC (Y/N):	Da		-	F	Run	Start Stop		
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr			May 1							
D3502	Rev	В		•								
		BAND SAW		0.00				10		,		
Bandsaw Jeaspa Bandsaw		Memo Cut blank 3	3.475 " long□1 BLANK MAI	0.00 KES 2 PARTS	L 10/12/20	Ò			7			
110 HAAS 1		HAAS CNC VERTICAL	_ MACHINING #1	0.00				_10		<u> </u>	····	
HAAS CNC vertica	l machine #1		er Folio FA649 Rev: AA 6 502		= 2-Deburr	11/01/1	/					
120		QC2- Inspect parts off n	nachine FAI/FAIB	0.00	0.11							

QC

Memo

on Kuloili

Quality Control

0.00

W/O:			W	ORK ORDER CHANG	ES			-		
DATE	STEP	PRO	OCEDURE CHA			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR:	Yes	No DQ	4 :	_ Date: _	
	Res	solution:	Dispositio	n:	_ QA: I	VC CIO	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE	(NCR)			
DATE	CTED	Description of NC		Corrective Action Secti			Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	,	Sign & Date	Secti		Chief Eng	QC Inspector

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Work Order ID 64004

Tuesday, November 23, 2010 9:27:46 AM



Page 2

Item ID:

D3502-1

Accept

Setup Start



Revision ID:

Item Name: **Start Date:**

Support

11/22/2010

Start Qty: 10.00

Required Date: 12/15/2010

Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: ____

Date:

Tooling:

Date:

Date:

Run

Start

Stop

Stop



QC:

Date:

SPC (Y/N):

0.00

Set Up/

Tool ID

Tool # Plan

Accept

Reject

Insp.

Sequence ID/ **Work Center ID**

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

11/0/11

Run Hours

Code

Qty Qty Reject

Number Stamp

140

Small Fab

Small Fab

Memo

0.00

0.00

Mark hole position using DT9430 □ Drill as per Dwg D3502.

150

HandFinish Hand Finishing

Small Fab

Memo

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

10 BL11-01-13

W/O:			W	ORK ORDER CHAN	IGES				, ,,,	
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
	Re	solution:	Disposition	on:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFOR	MANCE	(NCR)		·	
DATE	STEP	Description of NC	Description of NC Corrective Acti		V			cation	Approval	Approval
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Work Order ID 64004

Tuesday, November 23, 2010 9:27:46 AM

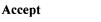


Page 3

Item ID:

D3502-1

Support





Setup Start



Revision ID:

Start Date:

Item Name:

Start Qty: 10.00 11/22/2010

Req'd Qty: 10.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



Required Date: 12/15/2010

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Code

Tool # Plan

Reject

Qty

Reject Insp.

Number

Stamp

Sequence ID/ **Work Center ID**

160

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Identify as per dwg & Stock Location: (6.3)

Memo

11:00

0.00

0.00

_□OYEN TEMPERATURE:

DFINISH TIME:

170

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Accept

Qty

10 \$ W 11/01/12

180

Packaging Packaging

0.00

0.00

(e4/0)/14(10)

Memo

W/O:			W	ORK ORDER CHANC	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 64004

Tuesday, November 23, 2010 9:27:46 AM



Page 4

Item ID:

D3502-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Support

Start Date:

Start Qty: 10.00

Cust Item ID: Customer:

Reference:

An	provals:	
N	DI O 1 44154	

Process Plan: ____

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Run

Stop

Start



Sequence ID/ Work Center ID

190

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

11/22/2010

Required Date: 12/15/2010 Req'd Qty: 10.00

Operation

Description

W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	tegory:	NCF	R: Yes I	No DQ	A :	Date:	
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DATE	STEP	Description of NC			ection B	0: 0	Verific		Approval	Approval
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Picklist Print

Tuesday, November 23, 2010 9:27:50 AM

Work Order ID: 64004

Parent Item:

D3502-1

Par at Item Name: Support



Start Date: 11/22 2010

Required Date: 12/15/2010

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 06-07-06 JLM

IPP Rev:B Add tooling hole 07-03-28

Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00		Purchased	No		100	f	56.3995	0.289	3.042105			

6061-T6 Bar 1.00 x 4.00

Location Loc Qty Loc Code MAT03 56.3995

107221 48.3937 114352 8.0058 SL 16/12/20

Dart Ae	rospace	e Ltd							٠. ١
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositi	on:	QA: N/C C	losed:		Date:	
NCR:		V	VORK ORE	DER NON-CONFORMAN	ICE (NCF	₹)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign & Date	I SECII	-	Approval Chief Eng	Approval QC Inspector

DART AEROSPACE LTD	Work Order:	64004
Description: Support	Part Number:	D3502-1
Inspection Dwg: D3502 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Pi	rototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R1.590	+/-0.010	R.1.596			High-gang	31604
R1.177	+0.005/-0.000	R.1.1775			Air	ML-03
0.130	+/-0.010	.125			Vern	ML-7
0.080	+/-0.010	.074			r(.,
0.928	+/-0.010	.936	_		1,	
0.100	+/-0.010	./0/	_		Λ <u>.</u>	11
0.100	+/-0.010	.092		-	1,	1.
1.39	+/-0.030	1.396			High-gage	31606
			···		1 1 1	
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	4			
Measured by:	arl	Audited by:	Prototype Approval:	N/A
Date:	ularly	Date: 110111	Date:	N/A

Rev	Late	Change	Revised by	Approved
Α	06.09.01	New Issue	KJ/JLM ,	1
В	07.03.29	Dwg Rev. updated	KJ/JLM OK	

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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NCR:		W	ORK OR	DER NON-CONFORMANC	E (NCI	₹)					
DATE	STEP	EP Description of NC Section A			Verifi	cation	Approval	Approval			
			Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector		

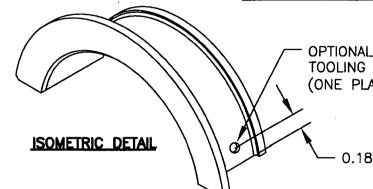
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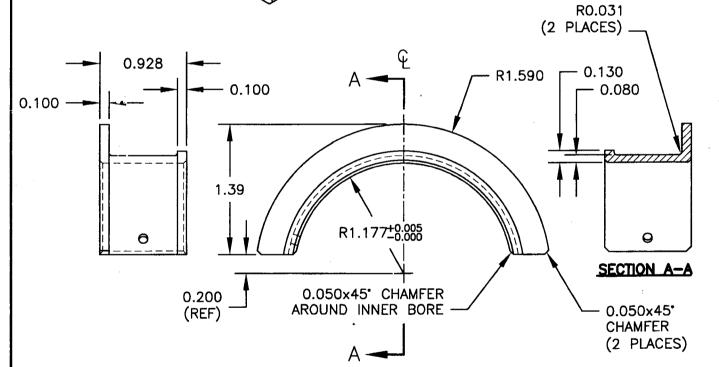
WORK ORDER NO. 44004

DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA CHECKED APPROVED DRAWING NO. REV. B D3502 SHEET 1 OF 1 TITLE SCALE DATE SUPPORT 06.10.31 06.04.18 **NEW ISSUE** В 06.10.31 ADD TOOLING HOLE FOR FINISHING



0810-11-23

OPTIONAL Ø0.098 (DRILL #40) TOOLING HOLE, CENTERED ON PART (ONE PLACE ONLY)



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCIS ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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